

WHAT IS CLAIMED IS:

1. An apparatus for an internal die cavity, comprising:
a die end plate having a front surface facing the internal die cavity,
a rear surface and defining an opening extending through said front and rear
5 surfaces;
an internal deckle mounting block attached to said rear surface of
said die end plate; and
an internal deckle having a longitudinal axis, an inner deckle
member and an outer deckle member and being mounted on said mounting block,
10 said inner deckle member extending through said opening of said die end plate
and defining a chamber and a first longitudinal slot, said outer deckle member
being positioned about said inner deckle member concentric therewith and
defining a second longitudinal slot, said inner deckle member being rotatable
relative to said outer deckle member to vary alignment of said slots and create a
15 passageway narrower than either of said slots.
2. An apparatus, as set forth in claim 1, wherein said inner deckle
member has a first end portion engaging said mounting block and being supported
thereby and has a second end portion containing said chamber and extending into
20 said internal die cavity.
3. An apparatus, as set forth in claim 2, wherein said chamber is a
longitudinal chamber having first and second end portions with said first end
portion having smaller dimensions than said second end portion and positioned
25 closer to said front surface than said second end portion.
4. An apparatus, as set forth in claim 2, wherein said chamber is a
longitudinal chamber having first and second end portions with said first end
portion having a smaller volume than said second end portion and positioned
30 closer to said front surface than said second end portion.
5. An apparatus, as set forth in claim 1 including means for

moving said inner deckle member axially to accommodate product width changes.

6. An apparatus, as set forth in claim 1 including means for moving said inner deckle member radially to vary said passageway.

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7. An apparatus, as set forth in claim 2, wherein said second end portion of said inner deckle member has a circumferential flange and defines a circumferential groove, said outer deckle member being seated on said inner deckle member between said flange and groove.

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8. An apparatus, as set forth in claim 7 including a retaining clip seated in said groove.

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9. An apparatus for an internal die cavity, said internal die cavity shaping resinous material into a web having edges, said apparatus comprising:
a die end plate having a front surface facing the internal die cavity, a rear surface and defining an opening extending through said front and rear surfaces;

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said die end plate; and

an internal deckle for controlling resin flow at an edge of the web, said internal deckle having a longitudinal axis, an inner deckle member, an outer deckle member and being mounted on said mounting block, said inner deckle member extending through said opening of said die end plate to a location near the path of an edge of the web, said inner deckle member defining a chamber and a first longitudinal slot parallel to said longitudinal axis, said outer deckle member being positioned about said inner deckle member concentric therewith and defining a second longitudinal slot parallel to said longitudinal axis, said inner deckle member being rotatable relative to said outer deckle member to vary alignment of said slots and create a passageway narrower than either of said slots.

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10. An apparatus, as set forth in claim 9, wherein said inner deckle

member has a first end portion engaging said mounting block and being supported thereby and has a second end portion containing said chamber and extending into said internal die cavity.

5 11. An apparatus, as set forth in claim 10, wherein said chamber is a longitudinal chamber having first and second end portions with said first end portion having smaller dimensions than said second end portion and positioned closer to said front surface than said second end portion.

10 12. An apparatus, as set forth in claim 10, wherein said chamber is a longitudinal chamber having first and second end portions with said first end portion having a smaller volume than said second end portion and positioned closer to said front surface than said second end portion.

15 13. An apparatus, as set forth in claim 9 including means for moving said inner deckle member axially to accommodate web width changes.

20 14. An apparatus, as set forth in claim 9 including means for moving said inner deckle member radially to vary said passageway to thereby adjust resin flow at an edge of the web.